

Date: Monday, 12/17/2007 9:24:51 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 36363		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 12/17/2007 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL / MED FAB	Drawing Revision	: C
Previous Run	: 36040	Material	:
Written By	: <u>07-12-17</u>	Due Date	: 12/24/2007 Qty: 50 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 07-02-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.9375 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 105997 EB 07-12-17

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

1B 07-12-17

2-Deburr if necessary

1B 07-12-17

58

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 07-12-17

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QCB	SECOND CHECK
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Comment: SECOND CHECK

counts
2/12/17 58

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

58 08/01/02 58

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36363

Part Number: D35371

Job Number:

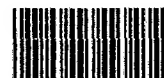


Seq. #: Machine Or Operation: Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

M106390

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

hsl 08/01/15 (58)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08/01/15 (58)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/15 (58)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M106442

M. 08/01/18 (58X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/01/18 (58)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F-P 20

M. 08/01/18 (58X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.21

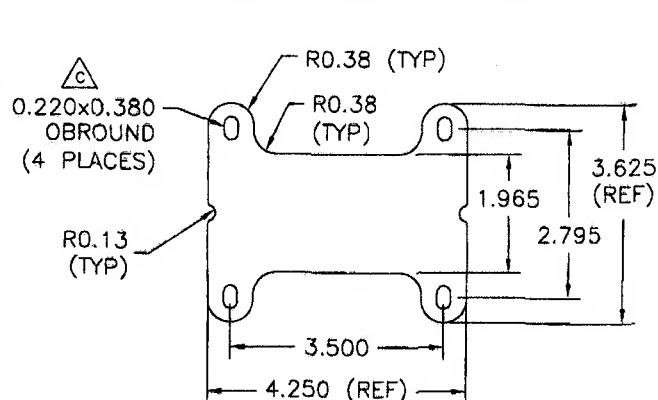
Job Completion



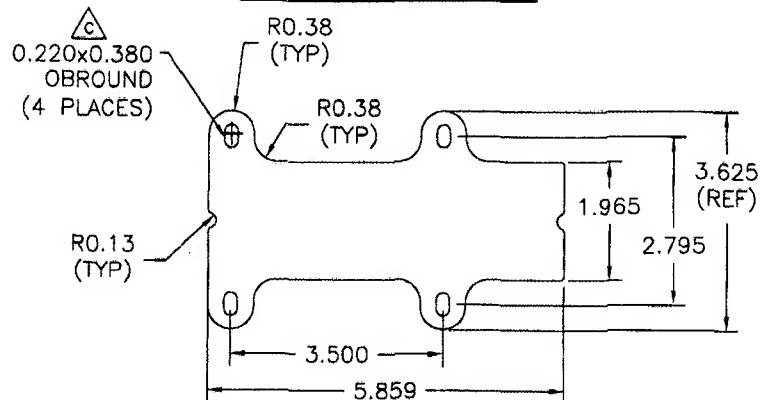
m 2008/1/21

U

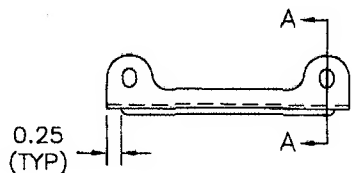
D3537-1F FLAT PATTERN



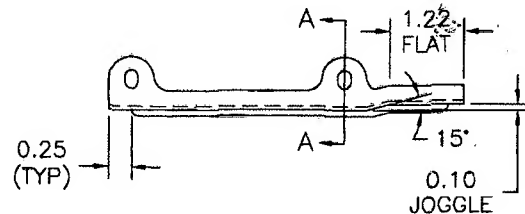
D3537-3F FLAT PATTERN



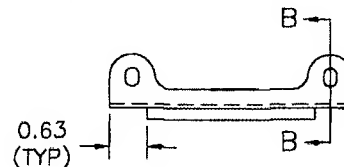
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



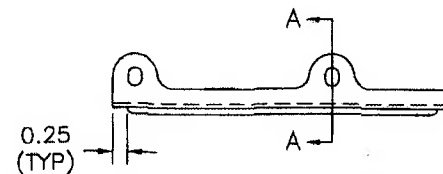
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



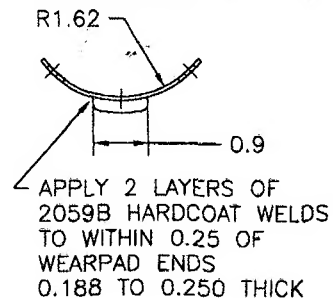
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



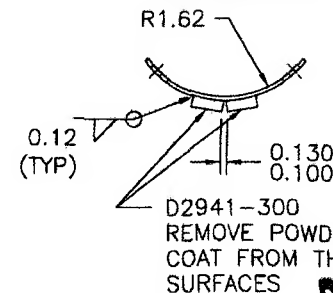
D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



SECTION A-A



SECTION B-B



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C SHEET 1 OF 1 SCALE 1:2

RELEASED
07-05-08 PM
PER ECU 962

DART AEROSPACE LTD		Work Order:	36363
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.251	X			
3.500	+/-0.010	3.500	X			
1.965	+/-0.010	1.964	X			
2.795	+/-0.010	2.795	X			
3.625	+/-0.010	3.617	X			
0.220 x 0.380	+/-0.010	0.225 x 0.385	X			

Measured by:	LB	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07-12-17	Date:	07/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM [Signature]	[Signature]